

# Work Order ID 78525

January-10-12 2:56:45 PM

*HAJ*  
**\*78525\***

Page 1

Item ID: D4357-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step, RH Crew  
 Start Date: 10/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 24/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4357	A

100 0.00

**\*100\***

Large Fab

Large Fab

Large Fab

Memo

1-Cut D4357-1 using D2622 extrusion as per Dwg D4357  
 2-Drill, c'sink one hole on top of step as per dwg  
 3-Deburr and bevel ends for welding

110

**\*110\***

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

120

**\*120\***

Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 114514  
117912 0.00

Memo

1-Weld end cap (ONE END ONLY)  
 2-Grind end cap welds flush  
 3-weld lugs as per Dwg D4357

*12.01.11* 1 0

*QC 12.01.11*  
*SV 12.01.11* 1 0

*12.01.11* 1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*78525\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 10/01/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 24/01/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

**Insp.  
Stamp**

0.00

\*130\*

QC

## Memo

0.00

## Quality Control

0.00

\*140\*

QC

## Memo

0.00

## Quality Control

0.00

**\*150\***

HandFinish

## Memo

0.00

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*78525\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 10/01/2012    **Start Qty:** 1.00    **\*1\***

Cust Item ID:

**Required Date:** 24/01/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

0.00

**\*160\***

OC

## Memo

0.00

## Quality Control

Weld per dwg A/R Aluminum rod Batch: *114514* 0.00

0.00

\*170\*

Large Fab

## Large Fab

## Memo

0.00

- 1-Inspect for foreign object per QSI 024
- 2-Weld Remaining end cap as per Dwg D4357
- 3-Grind end cap weld flush as per dwg D4357
- 4- install rivert as per dwg

QC10- Inspect visual per QSI004- ground welds	0.00
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0.00

**\*180\***

OC

## Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
200 <b>*200*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
210 <b>*210*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo	0.00 0.00							

W11A480

Start Time : 3:20  
 Temp : 320°F  
 Finish Time : 3:50

1X/M-12/01/12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
211	QC3- Inspect Part Finish	0.00							
<b>*211*</b>									
QC	Memo	0.00							
Quality Control									
215	Wing Walk as per dwg QSI005 4.4 Batch <u>112094</u>	0.00							
<b>*215*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
220	QC3- Inspect Part Finish	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									

count identified 12/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 Required Date: 24/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230 Identify as per dwg & Stock Location: ST

0.00

**\*230\***

Packaging

Memo

0.00

Packaging

240

QC21- Final Inspection - Work Order Release

0.00

**\*240\***

QC

Memo

0.00

Quality Control

PPP 78506

SP 12-01-16

12/1/17

12-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

January-10-12 2:56:49 PM

Page 1

Work Order ID: 78525

**\*78525\***

Parent Item: D4357-042

**\*D4357-042\***

Parent Item Name: Step, RH Crew

Start Date: 10/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-01-10 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120 <b>*D2622-120*</b> Step Extrusion		Manufactured	No		368293		Each	0.0000		0.1		12.01.11	
D2734 <b>*D2734*</b> Step End Plate		Manufactured	No				Each	144.0000		2		12.01.11	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			135						
				76985			135						
				WA015			9						
				73416			9			2			
D3461-1 <b>*D3461-1*</b> Mounting Plate		Manufactured	No				Each	46.0000		1		12.01.11	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA003			46						
				58756			46			1			
D3461-3 <b>*D3461-3*</b> Mounting Plate		Manufactured	No				Each	3.0000		1		12.01.11	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA017			3						
				41601			3			1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January-10-12 2:56:49 PM

Page 2

Work Order ID: 78525

**\*78525\***

Parent Item: D4357-042

**\*D4357-042\***

Parent Item Name: Step, RH Crew

Start Date: 10/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W2

Purchased

No

Each

176.0000

1

**\*MS20601-AD4W2\***

**\*\***

*12.01.11*

Rivet

Location

Loc Qty

Loc Code

ST322

176

119232

176

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

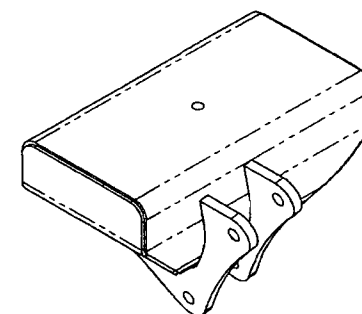
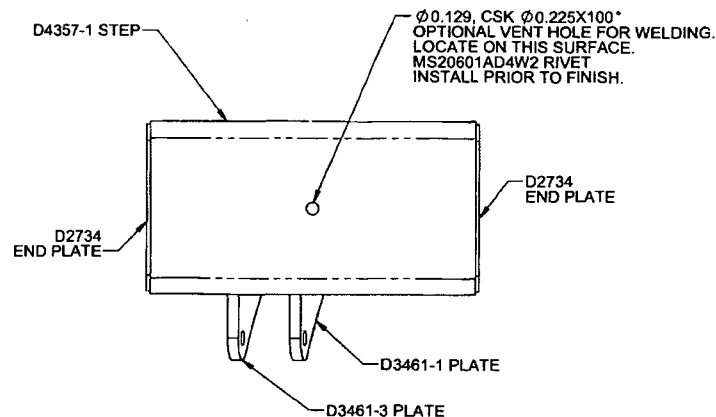
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

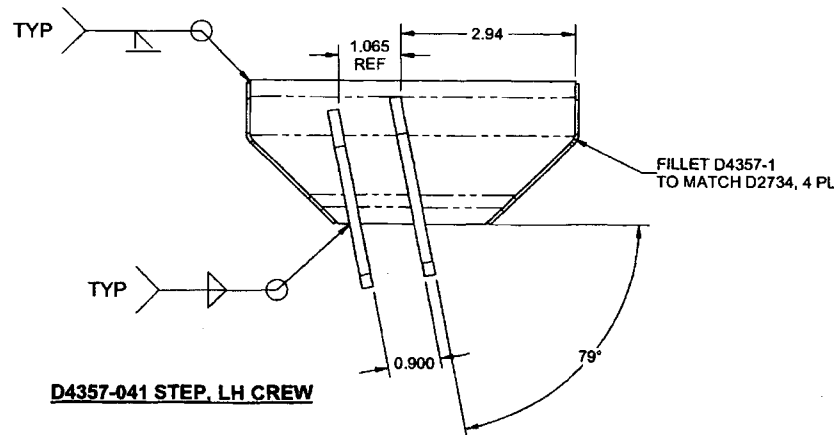
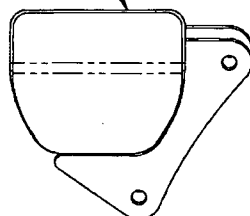
**NOTE:** Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
1	X	D4357-041	STEP, LH CREW
2	1	D4357-1	STEP
3	2	D2734	END PLATE
4	1	D3461-1	PLATE
5	1	D3461-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHOUT NOTICE  
WORK ORDER  
NO. 78525 M.C.J

12/01/18

RELEASED  
2011-05-20

NTS

# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	CP	10.12.17
REV.	DESCRIPTION	BY	DATE
DESIGN	AS		
DRAWN	AS		
CHECKED	AS		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	10.12.17		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4357  
REV. A  
SHEET 1 OF 3

TITLE  
STEP, CREW  
SCALE  
NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

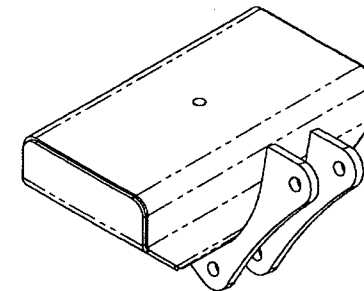
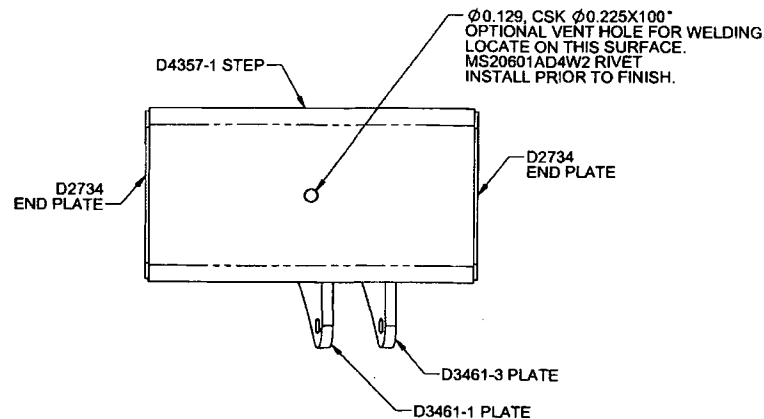
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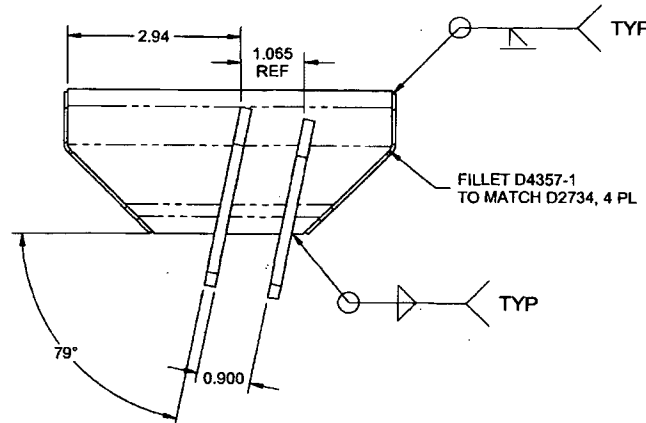
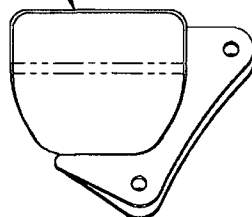
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78525

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4357-042	STEP, RH CREW
2	1	D4357-1	STEP
3	2	D2734	END PLATE
4	1	D3461-1	PLATE
5	1	D3461-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



**D4357-042 STEP, RH CREW**

**RELEASED**  
2011-05-20  
JM

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4357</b> REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE <b>STEP, CREW</b> SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	<b>10.12.17</b>	

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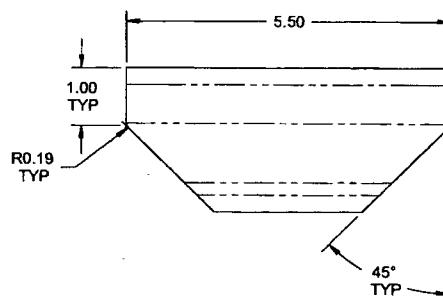
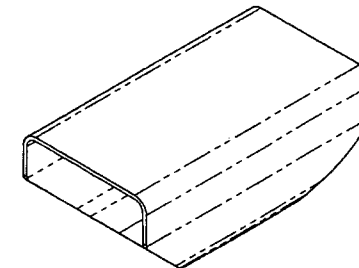
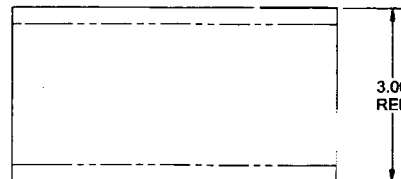
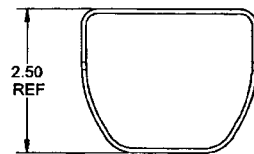
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

78525



**D4357-1 STEP**

**RELEASED**  
2011-05-26

- NOTES:**
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.33 lbs

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	MP	D4357	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	STEP, CREW	NTS
DATE	10.12.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries